

# Work Order ID 78540

**\*78540\***

Page 1

January-11-12 10:51:57 AM

Item ID: D3245-041 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Access Panel Assembly  
 Start Date: 11/01/2012 Start Qty: ~~6.00~~ **\*6\*** Cust Item ID:  
 Required Date: 25/01/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: U.C.J Date: 12/01/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3245	Rev B								
100	Pick Kit	0.00							
<b>*100*</b>									
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
<b>*110*</b>									
Small Fab	Memo	0.00							
Small Fab	Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245be careful when countersinking...mat'l very thin								
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

*EP 12/04/03 (6)*

*EP 12/04/03 (6)*

*Sizlat*

*(6)*  
*-cel*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

January-11-12 10:51:57 AM

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212-04-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

January-11-12 10:52:01 AM

**\*78540\***

**\*D3245-041\***

**Required Qty: 6.00**

**Comments:** IPP Rev :A New Issue 07-09-11 JLM Verified By:EC  
IPP Rev:b ECN 1052 07-10-31 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2350-18-C3Y <b>*2350-18-C3Y*</b> RIGID RECEPTACLE		Purchased	No			110	Each	82.0000	8	48			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST400		82							
				105729		2							
				118457 ~		41							
				118752 -		19							
				19688		20							
D3245-1 <b>*D3245-1*</b> Panel		Manufactured	No			110	Each	0.0000	1	6			
						B78621		(6/20/03)	**				
D3245-5 <b>*D3245-5*</b> Door		Manufactured	No			110	Each	12.0000	1	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST233B		12							
				71671		2							
				72148		10							
MS20427M3-3 <b>*MS20427M3-3*</b> Rivet		Purchased	No			110	Each	1,204.000	16	96			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST318		1204							
				118384		1204							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January-11-12 10:52:01 AM

Page 2

Work Order ID: 78540

\*78540\*

Parent Item: D3245-041

\*D3245-041\*

Parent Item Name: Access Panel Assembly

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 6.00

Required Qty: 6.00

MS20615M3-3

Purchased

No

110

Each

1,394.000

9

54

\*MS20615M3-3\*

Rivet

\*\*

*CP 12/04/12*

Location

Loc Qty

Loc Code

ST323

1394

111650

12

116188

12

118384

1370

*M1191080542*

~~*1119356*~~  
*542*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

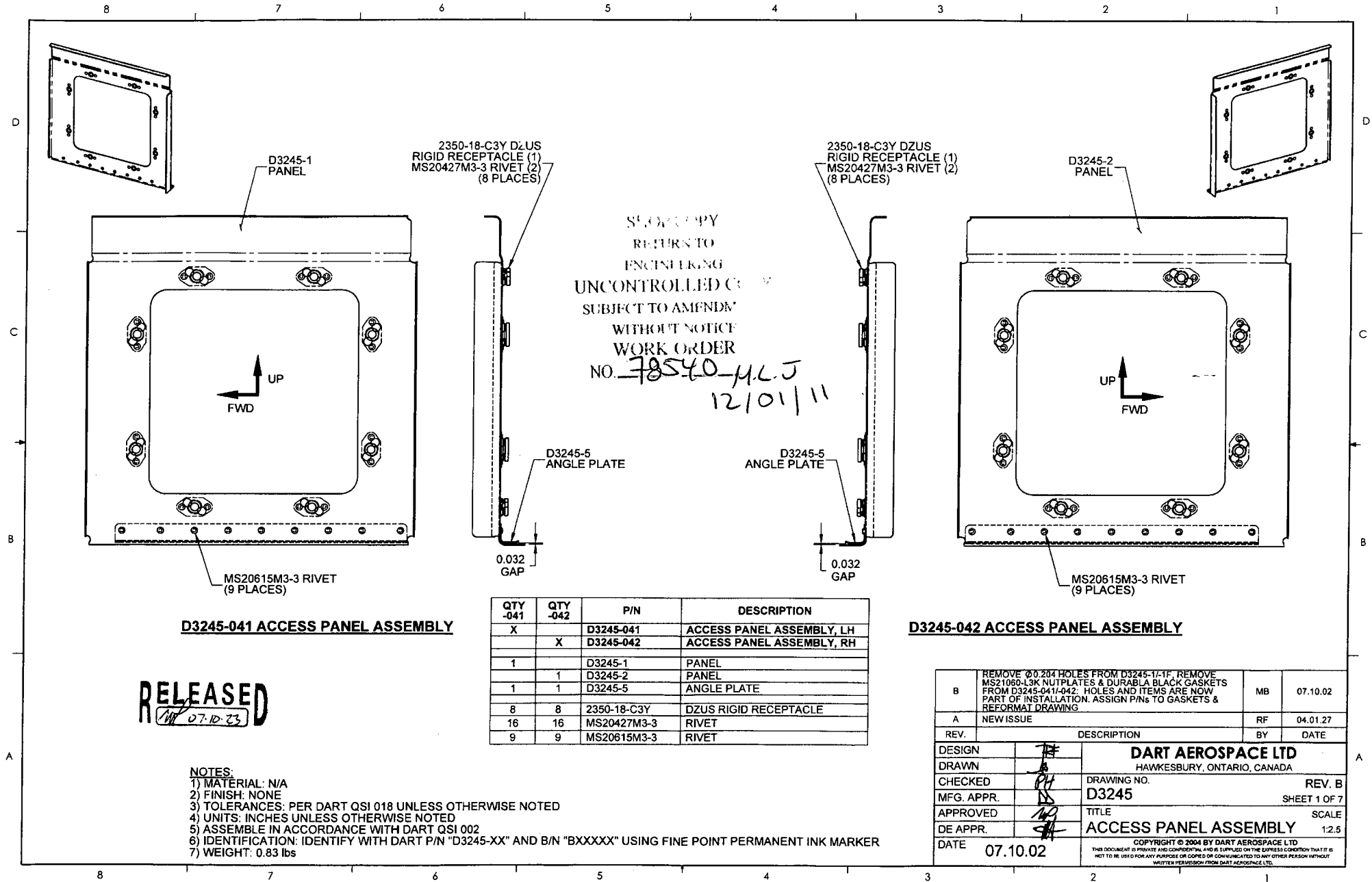
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3245-041 ACCESS PANEL ASSEMBLY**

**D3245-042 ACCESS PANEL ASSEMBLY**

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

**RELEASED**  
07-10-23

- NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.83 lbs

B	REMOVE Ø0.204 HOLES FROM D3245-1-1F, REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3245</b> TITLE <b>ACCESS PANEL ASSEMBLY</b> SCALE 1:2.5 SHEET 1 OF 7 REV. B DATE 07.10.02 <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

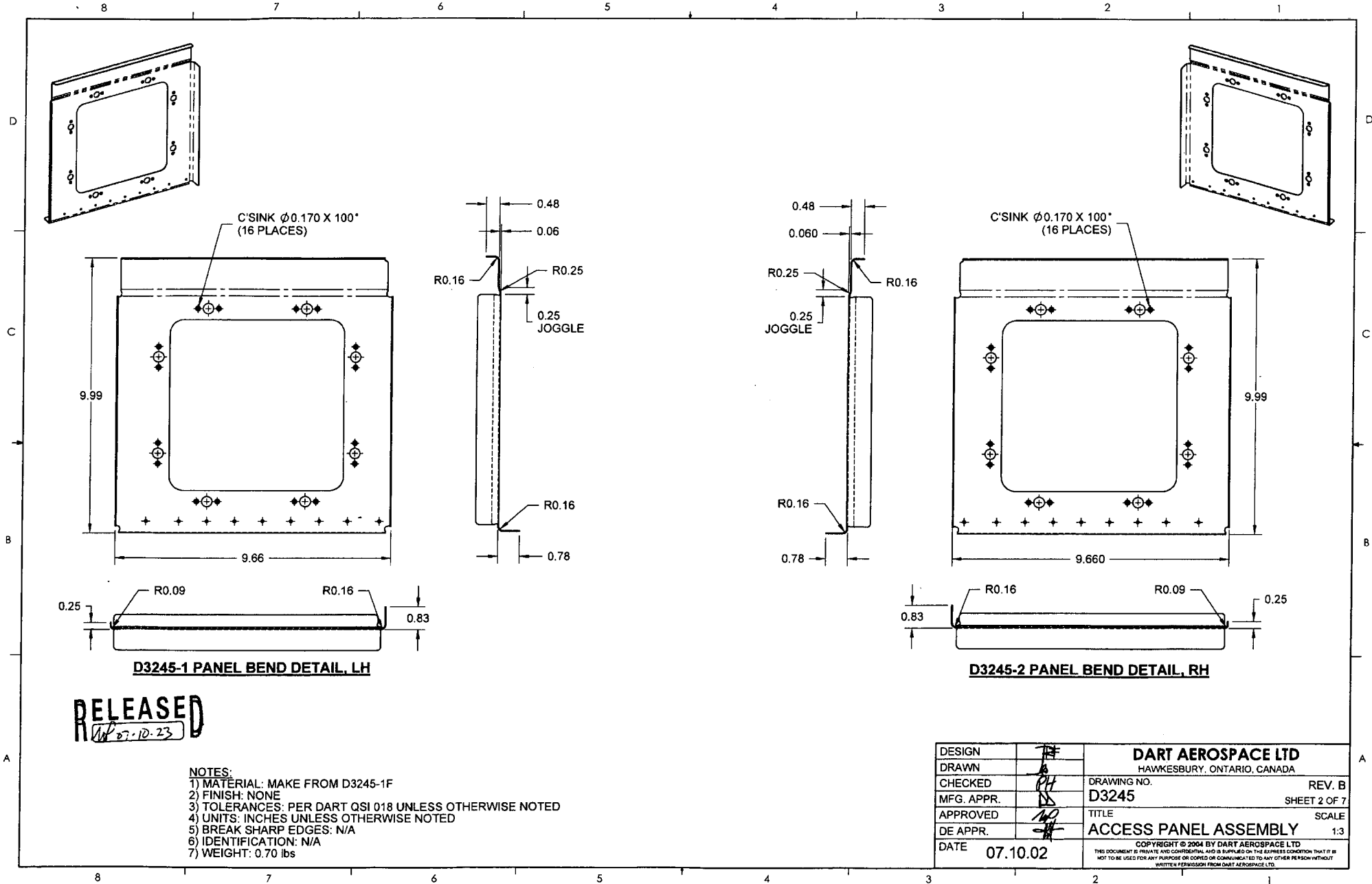
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78540



RELEASED  
10-27-10-23

- NOTES:
- 1) MATERIAL: MAKE FROM D3245-1F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

DESIGN	<del>TH</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>PH</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>PH</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>DS</del>	D3245	SHEET 2 OF 7
APPROVED	<del>NO</del>	TITLE	SCALE
DE APPR.	<del>TH</del>	<b>ACCESS PANEL ASSEMBLY</b>	
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

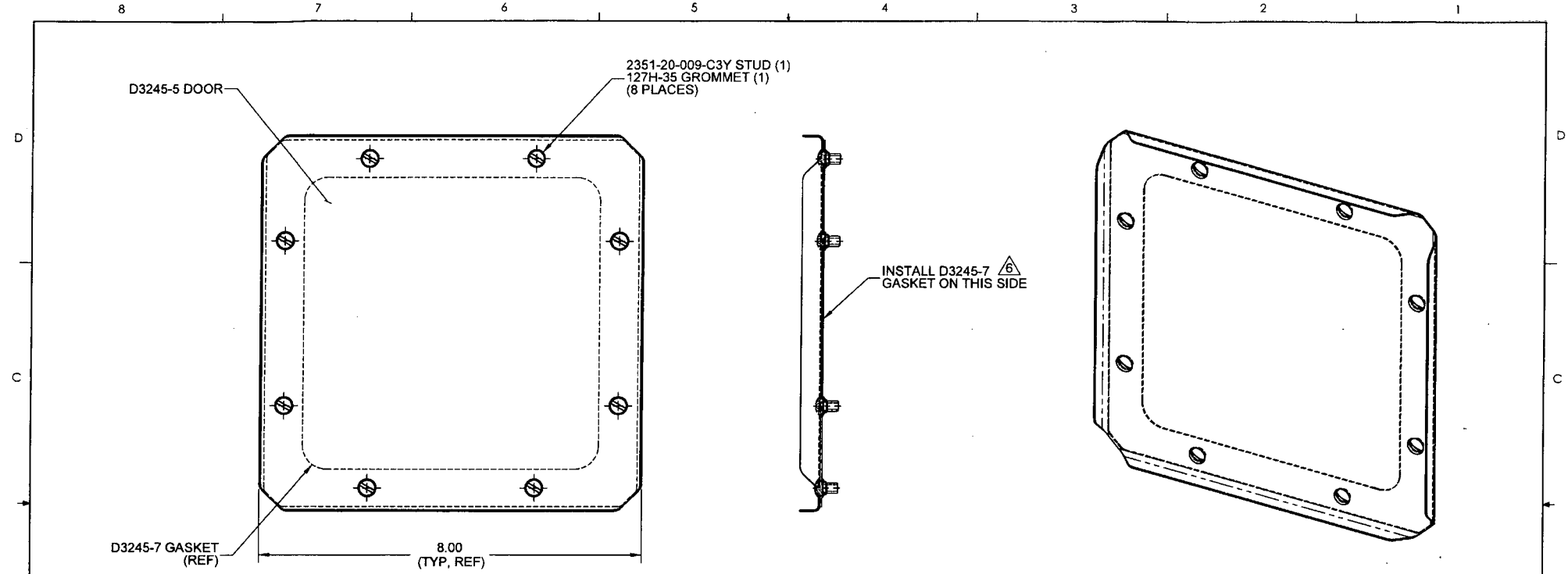
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**D3245-043 DOOR ASSEMBLY**

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

RELEASED  
17-10-23

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
  - 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
  - 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
  - 9) WEIGHT: 0.73 lbs

DESIGN	TH	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	TH	SHEET 3 OF 7	
APPROVED	TH	TITLE <b>ACCESS PANEL ASSEMBLY</b>	SCALE 1:2
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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

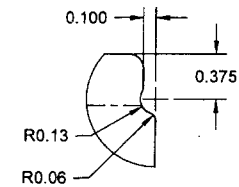
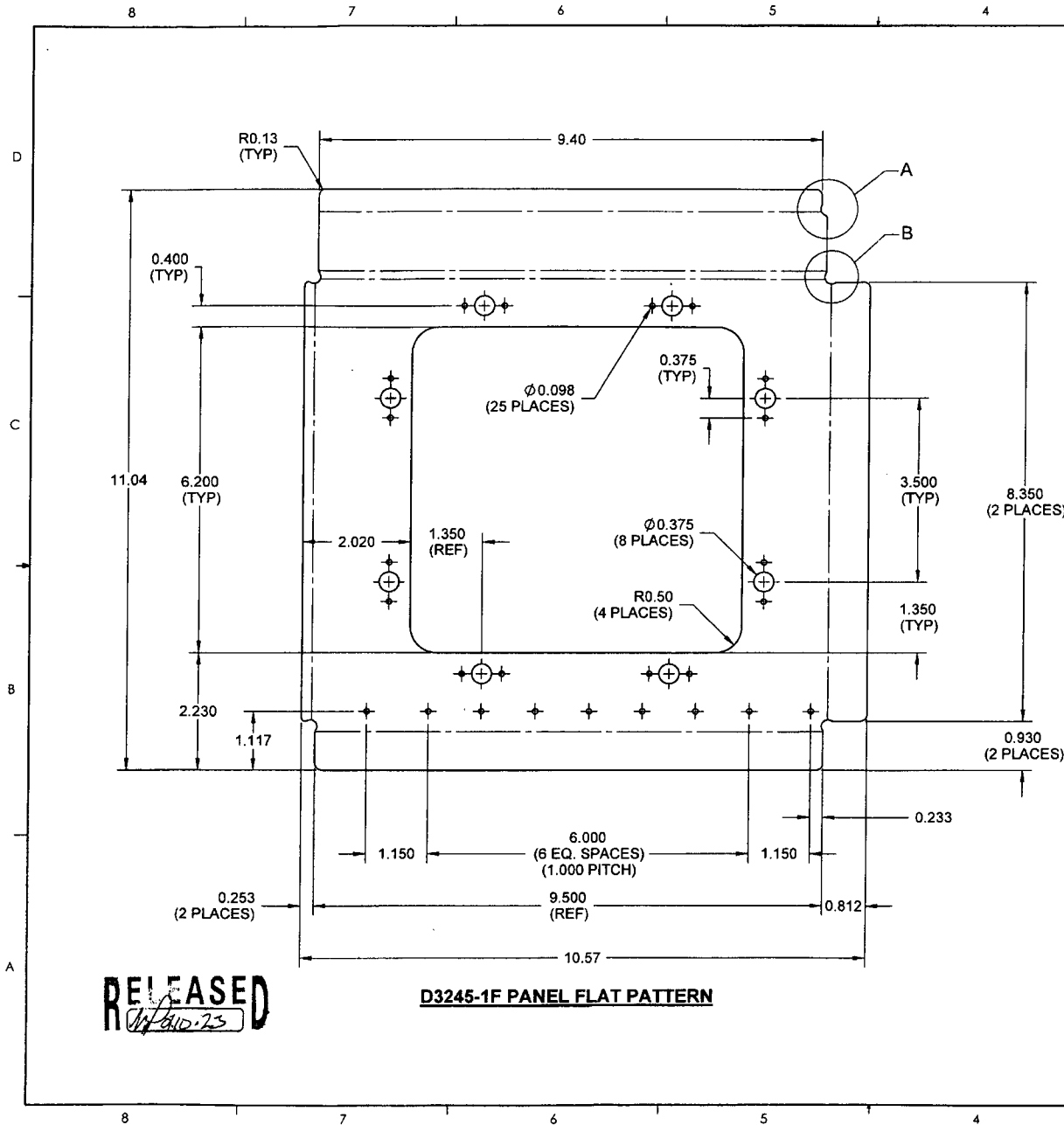
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

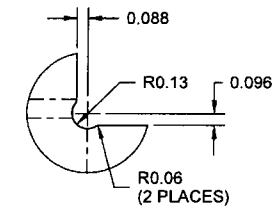
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78540



**DETAIL A: RELIEF**  
SCALE 1:1



**DETAIL B: RELIEF**  
(TYP. 4 PLACES)  
SCALE 1:1

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET  
(0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	#	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	<b>D3245</b>	SHEET 4 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	<b>ACCESS PANEL ASSEMBLY</b>	1:2
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED  
11/10/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

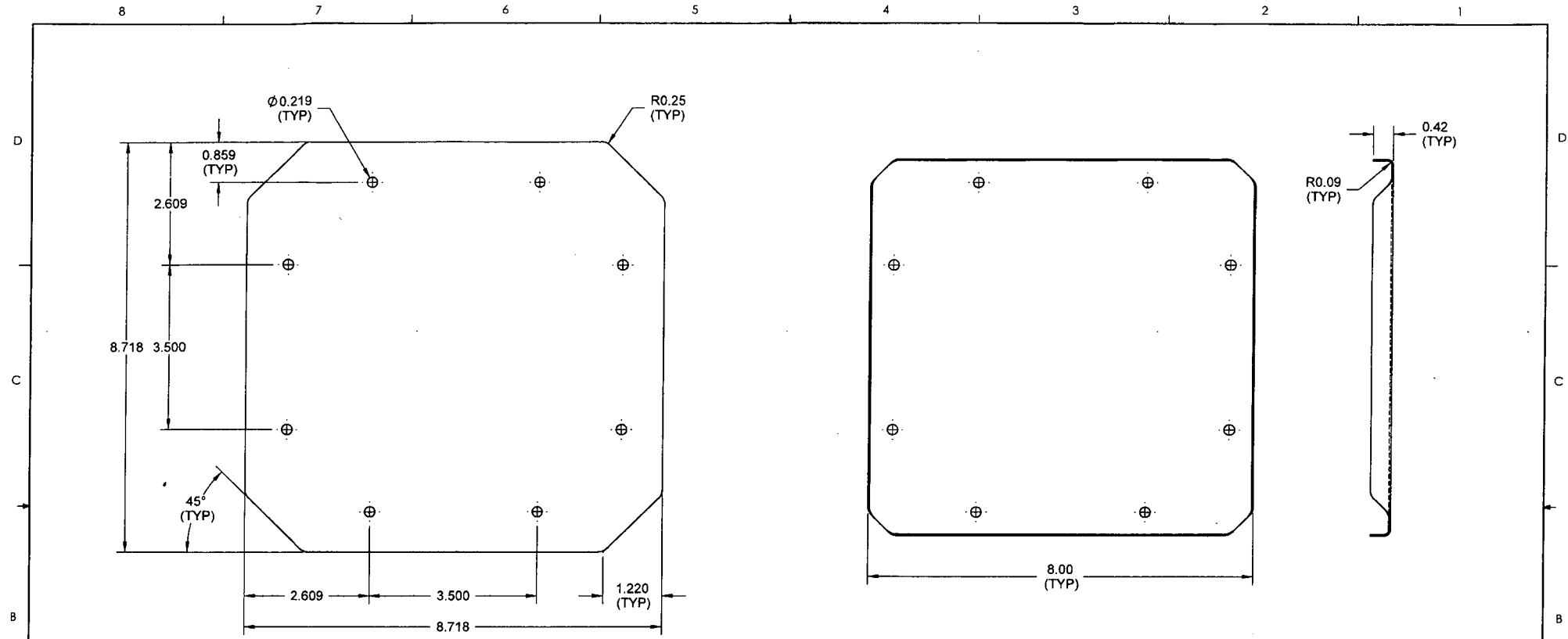
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

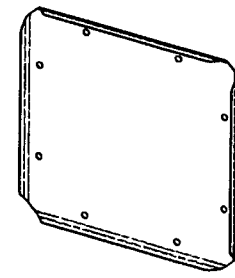


70540



RELEASED  
07-10-03

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.67 lbs



DESIGN	<del>70540</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>PH</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>DS</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>70540</del>	D3245	SHEET 5 OF 7
APPROVED	<del>70540</del>	TITLE	SCALE
DE APPR.	<del>70540</del>	ACCESS PANEL ASSEMBLY	1:2
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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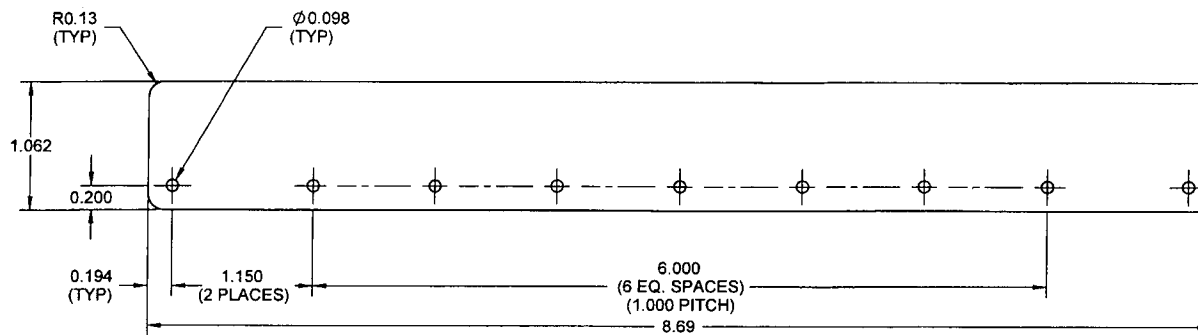
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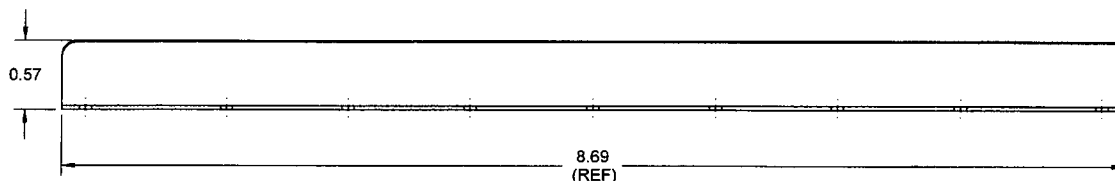
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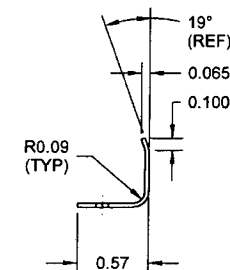
70540



**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL  
(MAKE FROM D3245-5F)**



**RELEASED**  
07.10.23

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.08 lbs

DESIGN	<b>D3245</b>	<b>DART AEROSPACE LTD</b>	
DRAWN	<b>PH</b>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<b>NS</b>	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	<b>NS</b>		SHEET 6 OF 7
APPROVED	<b>NS</b>	TITLE	SCALE
DE APPR.	<b>NS</b>	<b>ACCESS PANEL ASSEMBLY</b>	1:1
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W/O:		WORK ORDER CHANGES					
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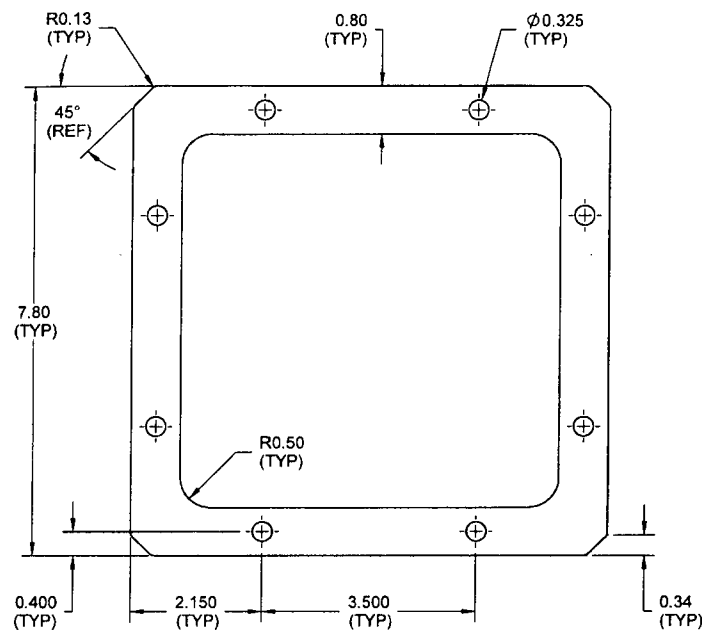
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

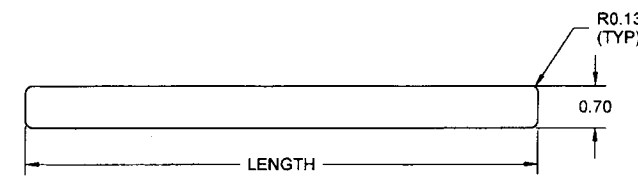
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78540



**D3245-7 GASKET**



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED  
07.10.02

- NOTES:**
- 1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK  
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A

DESIGN	<del>78</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>PH</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>PH</del>	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	<del>DS</del>		SHEET 7 OF 7
APPROVED	<del>PH</del>	TITLE	SCALE
DE APPR.	<del>PH</del>	<b>ACCESS PANEL ASSEMBLY</b>	1:2
DATE	07.10.02	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries